

Work Order ID 56809

March 10, 2010 1:30:51 PM



Page 1

Item ID:	D2991-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Side Door					
Start Date:	10/03/2010	Start Qty:	1.00			
Required Date:	18/03/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10-3-10	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2991	D								

110		0.00							
	Purchasing								
Purchasing									
Purchasing									
	Memo	0.00							
	Issue P/O: 11490								
	Description: D2991-1 side door								
	Supplier: Delastek								
	Ship to delastek: Qty 2 D2992-1 Doubler batch: 17743								
	Certificate of Conformity and process sheet from Delastek								

PS 10-3-10
①

120		0.00							
	Packaging								
Packaging									
Packaging									
	Memo	0.00							
	Ensure certificate of conformity is attached								

PS 10/4/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID:	D2991-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Side Door					
Start Date:	10/03/2010	Start Qty: 1.00		Cust Item ID:		
Required Date:	18/03/2010	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo Ensure Material certification comply to Dwg D2991	0.00	S 10/04/28			⑩			
140 	Identify as per dwg & Stock Location: <u>composites</u>	0.00							
Packaging Packaging	Memo	0.00					25	10-04-28	
150 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							10/04/28 J mf 10-4-28.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March 10, 2010 1:30:55 PM

Page 1

Work Order ID: 56809

Parent Item: D2991-1

Parent Item Name: Side Door



Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC
IPP Rev:B 08-02-20 ECN 1096 DD verified by:EC

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2991-1P		Purchased	No			110	Each	1.0000	1.0000			
						B56809				ET 10-04-28		
SIDE DOOR												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

D2991-1/-2/-3 SIDE DOOR

NOTES

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56809
BS-0-3.0

RELEASED
2009-10-30
W

D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>g</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>g</i>		
CHECKED	<i>g</i>		
MFG. APPR.	<i>g</i>		
APPROVED	<i>g</i>		
DE APPR.	<i>g</i>	DRAWING NO.	REV. D
DATE	09.09.26	D2991	SHEET 1 OF 5
		TITLE	SCALE
		SIDE DOOR	NTS
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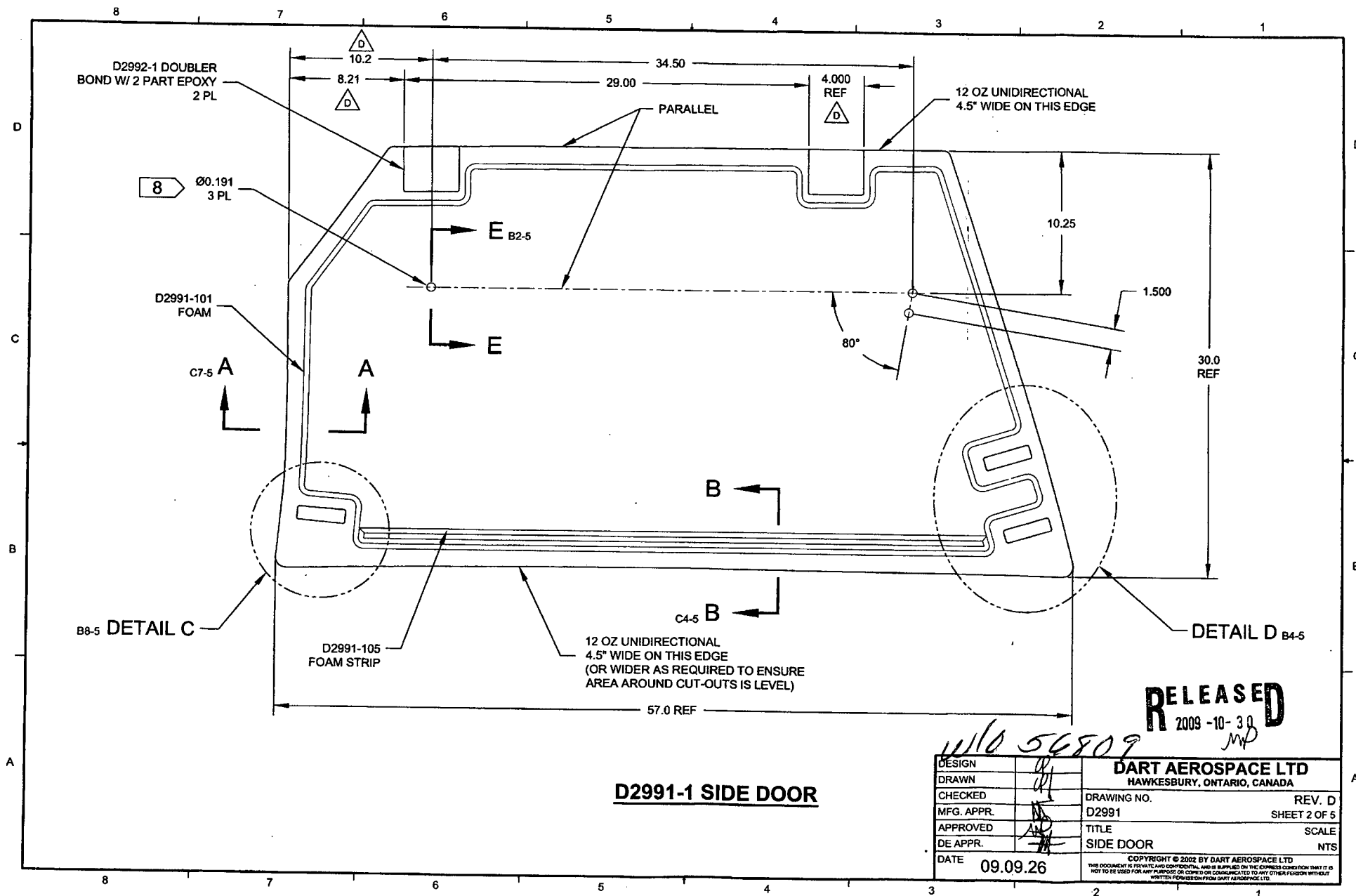
W/O:		WORK ORDER CHANGES					
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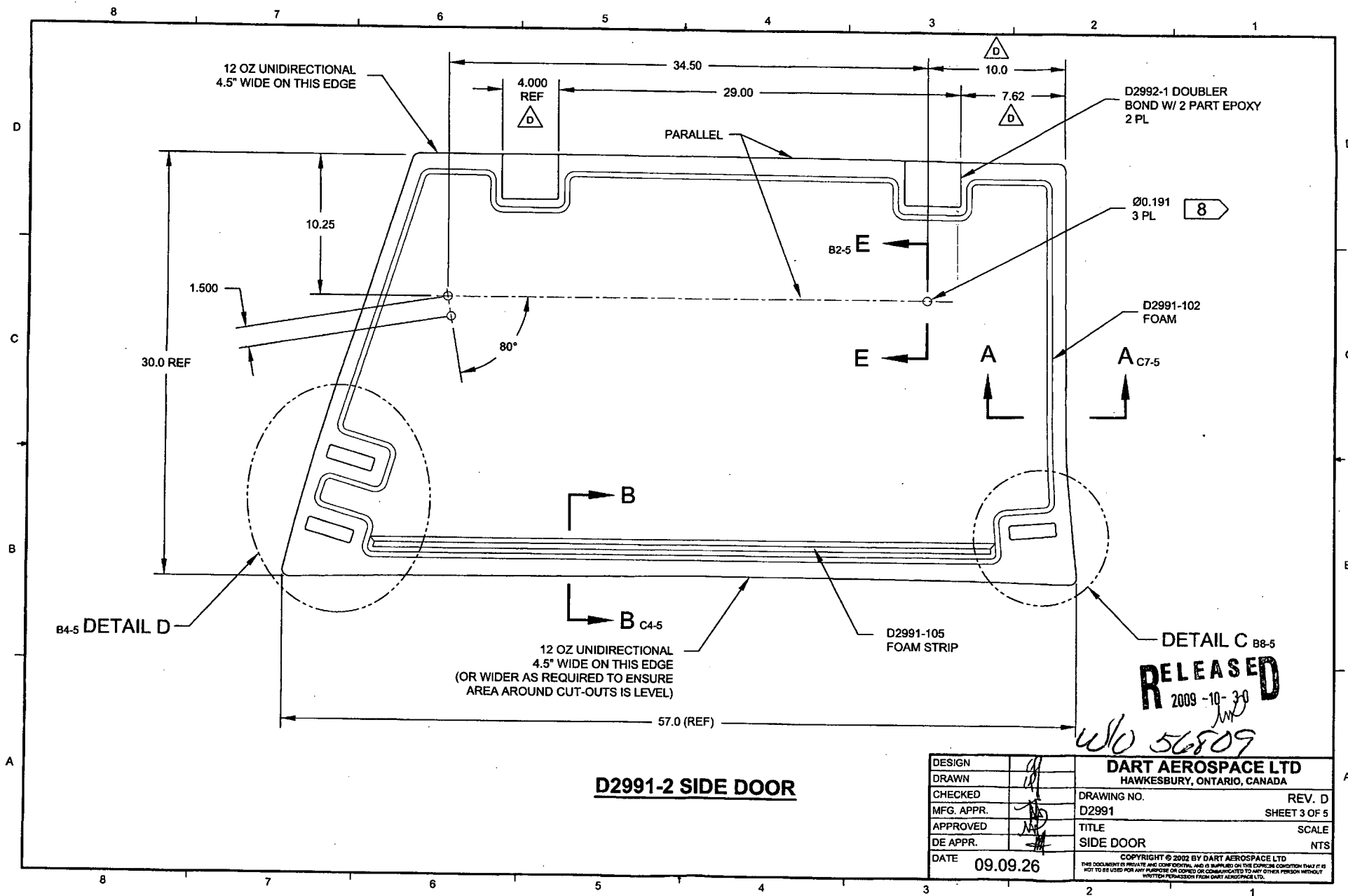
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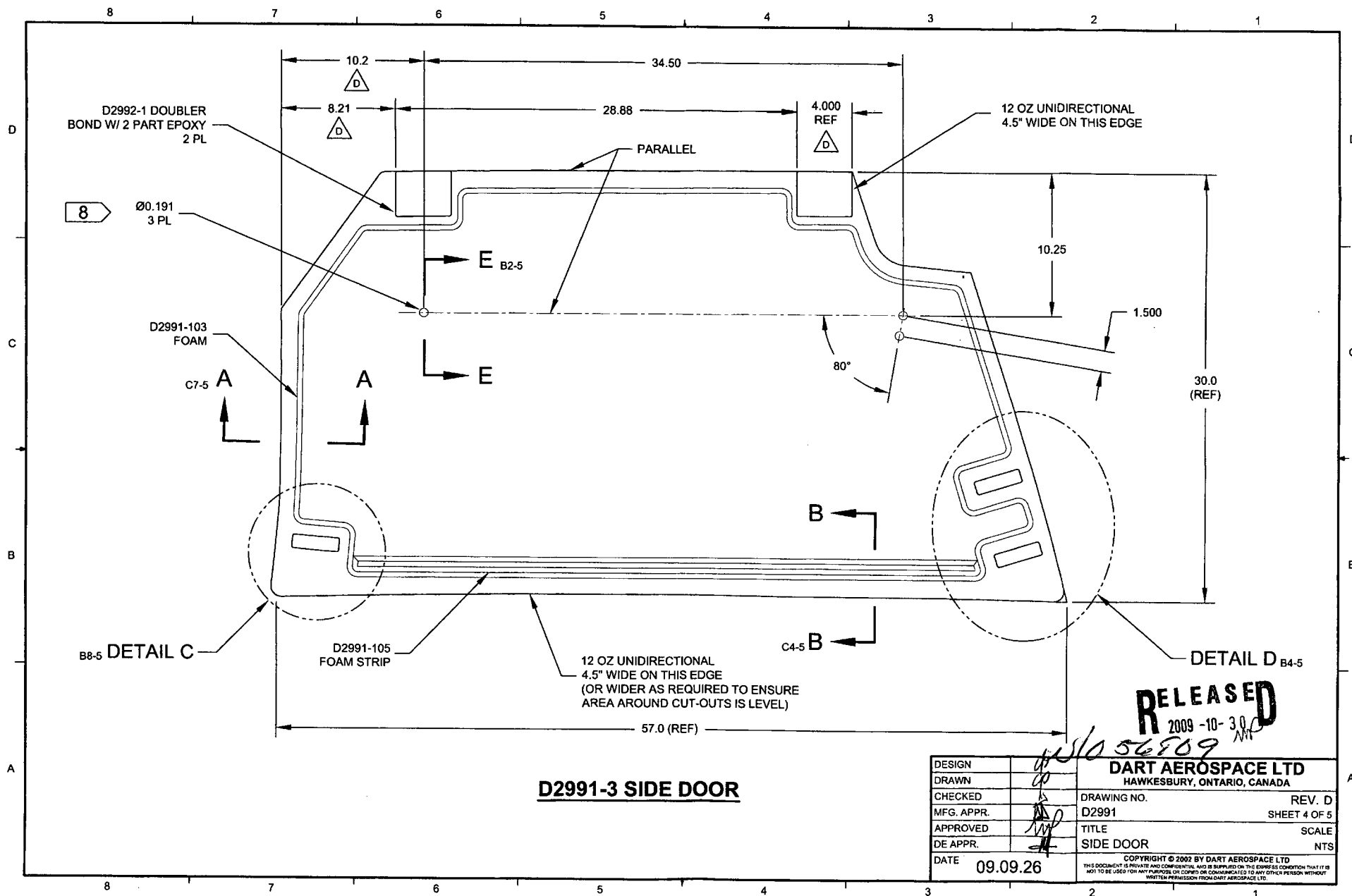
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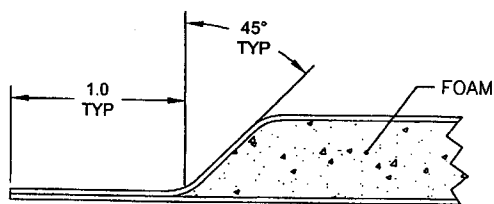
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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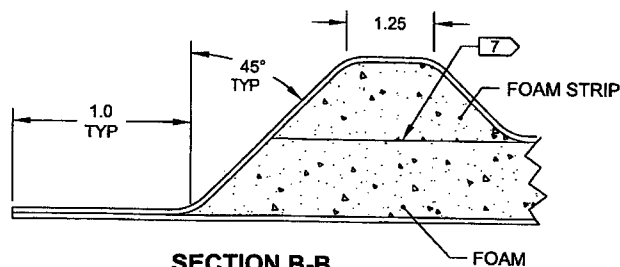
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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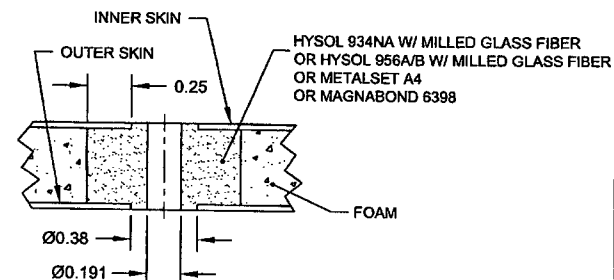
NOTE: Date & initial all entries



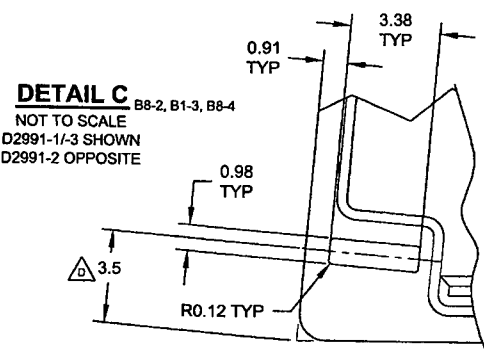
SECTION A-A
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



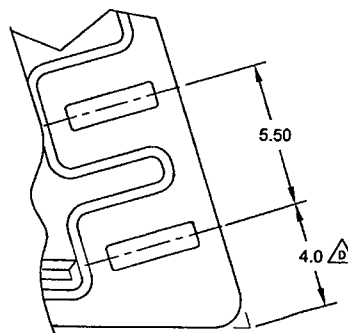
SECTION B-B
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E
D6-2, D3-3, C6-4
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE



DETAIL C
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

RELEASED
2009-10-30
1/14

W10 56809

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2991	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.09.26	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	32600
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #		
23/04/2010	10/03/2010	13674	Brigitte Golden	PO114790			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0066	Line #1 Side Door N° D2991-1 B56809 Dwg.: D2991 Rév.: D No. lot 24882 <i>Soloubz</i> U de M : Each Qté 1			
1	0	1	DKC134-0067	Line #2 Side Door N° D2991-2 B56810 Dwg.: D2991 Rév.: D No. lot 24883 <i>Soloubz</i> U de M : Each Qté 1			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.


☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department AQ-357

Date: Jeudi, 2010-03-11 15:52:50
Utilisateur: marc dubé

Feuille de Procédé

Client :	DART US DART AEROSPACE LTD	Nom Dessin :	SIDE DOOR N. D2991-1
Numéro Job :	24882	Numéro Article :	DKC134-0066
Numéro Soumission :	3756	Numéro Dessin :	D2991
Numéro B.A. :		Projet Numéro :	DK-134
Cette fois :	2010-03-11 No. B.V. :	Révision dessin :	D
Prsht Rev. :	NC	Matériel :	Composites
Prem. fois :	- - Type :	Date Dûe :	2010-03-18
Job précédente :	24647	Qté:	1 Udm: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N. de pièce client: D2991-1		

Process Sheet Rév.: 00 Création du premier dans DKA à partir de la
Rév.: 00 De DKC

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC0854 Frekote #700-NC

Commentair Qty.: 0.025 UNITE(s)/Unit Total : 0.025 UNITE(s)

2.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DKO-0094 laisser sécher pendant 3 heures selon le QSI-006 et IG 0009.

Date: _____ Sceau: _____

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

1-26570-1

Commentair Qty.: 0.040 UNITE(s)/Unit Total : 0.040 UNITE(s)

4.0 AMB0286 Catalyst N° DDM-9

1-22176-1

Commentair Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)

5.0 AAC1606 UN2055 styrene monomere ST

Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation et l'application du Gel coat selon IG0019, et diluer à l'aide de 5% de UN2055 styrene monomere ST

Date: 19-3-10 Sceau:  Temps Début: _____ Temps Fin: _____

Date: Jeudi, 2010-03-11 15:52:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24882

Nom Dessin: SIDE DOOR N. D2991-1
Numéro Article: DKC134-0066

Numéro Job:




# Séq.:	Machine ou Opération:	Description :
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23.0	ASSEMBLAGE	Assemblage mécanique
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Scaler le foam core selon IG005  *26/03/2010*
Installer le Foam Core D2991-101 selon IG 0033

Date: *29-3-10* Heure Début: — Heure Fin: — Sceau:  



24.0	BAGGING	Faire le bagging sur la pièce
------	---------	-------------------------------



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 2 heures minimum.

Date: *29-3-10* Sceau:  

Curing Début: *2:25* Curing Fin: *3:45*

25.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)

26.0	AMB0286	Catalyst N° DDM-9
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Commentair Qty.: 0.0020 GALLON(s)/Unit Total : 0.0020 GALLON(s)

27.0	PREP-GENERAL	Préparation du matériel
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: *6-4-10* Heure Début: — Heure Fin: — Sceau: 

28.0	LAMINAGE	Faire le laminage
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Se
Faire le laminage du pli de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SIDE DOOR N. D2991-1

Numéro Job: 24882

Numéro Article: DKC134-0066

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Faire le laminage du dernier pli de 9.7 oz.

Date: 6-4-10 Heure Début: — Heure Fin: — Sceau: 34 7

29.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Date: 6-4-10 Heure Début: — Heure Fin: — Sceau: 34 7* Curing Début: 10:30 Curing Fin: 8:00

30.0

DÉMOULAGE.

Démoulage



Commentair Setup: 0.00Hrs/ Run: 5.0000Hrs Total Run : 5.0000Hrs

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018

Date: 7-4-10 Sceau: 34 7

31.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

À l'aide du gabarit DKC-0369 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2991.

Date: 7-4-10 Sceau: 34 7

32.0

AAC0205

COLLE HYSOL EA934NA

1-26267-1

Commentair Qty.: 0.15 KIT(s)/Unit Total : 0.15 KIT(s)

33.0

AAC1540

Fibre de verre Miapoxy 66

1-7076-1

Commentair Qty.: 0.0037 GALLON(s)/Unit Total : 0.0037 GALLON(s)

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24882

Nom Dessin: SIDE DOOR N. D2991-1
Numéro Article: DKC134-0066

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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34.0	TRIMAGE	Trimage / Rivetage
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du Gabarit N° DKO-0369 Percer les 3 trous de 3/8" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 7/8" Dia dans le Foam Core entre les Skin intérieur et extérieur.

À l'aide de masking Tape, masquer le trou de la skin extérieur.

À l'aide d'un mélange 10:1 de résine Hysol EA934NA / Fibre courte Miapoxy 66 et d'une seringue, venir remplir les dégagements de 7/8" Dia préalablement fait dans le foam Core.

Laisser sécher.



Date: 7-4-10 Sceau:  

35.0	TRIMAGE	Trimage / Rivetage
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N° DKO-0369 Repercer les 3 trous de 0.191" Dia.

Date: 8-4-10 Sceau:  

36.0	AAC0205 AAC002	COLLE HYSOL EA934NA A l'aide de 2012	1-26592-1
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Commentair Qty.: 0.13 KIT(s)/Unit Total: 0.13 KIT(s)

37.0	AAC1681	N° D2992-1, Doubler	1-26921-1
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Commentair Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)

38.0	ASSEMBLAGE	Assemblage mécanique
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide de l'adhésif N° Hysol EA934NA, assembler le doubler N° D2992-1 sur la pièce de composite selon le dessin.

Date: 8-4-10 Sceau:  

39.0	AAC1021	Dupont Primer N° 7704S
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Commentair Qty.: 0.1800 UNITE(s)/Unit Total: 0.1800 UNITE(s)

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SIDE DOOR N. D2991-1

Numéro Job: 24882

Numéro Article: DKC134-0066

Numéro Job:



Séq.:

Machine ou Opération:

Description :

40.0 AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)

41.0 PRIMER

Application primer



Sablage finition



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

13-4-10
Préparer et appliquer le primer selon I.G. 0008 et la fiche technique.

Date: 09/04/10 Sceau: # de fiche de mélange: 11/13

42.0 INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection selon le dessin N° D2991

Date: 14-4-10 Heure Début: _____ Heure Fin: _____ Sceau:

43.0 EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'emballage des pièces.

Quantité: 1 Date: 14-4-10 Sceau: